



Tecnostamp



PRESS BRAKE TOOLING
www.tecnostamp.eu

ED26



EXPERIENCE & INNOVATION



TECNOSTAMP, fondata nel 1978 a Piacenza, è diventata nel corso degli anni, una delle più grandi ed affermate aziende italiane nella produzione, progettazione e vendita di utensili di piegatura; in continua espansione grazie ad una capillare rete di rivenditori dislocati in ogni parte del mondo. In questa direzione molti investimenti sono stati fatti: l'acquisto di nuove macchinari e l'esigenza di dotarsi di tecnologie avanzate con lo scopo di incrementare il livello qualitativo e la gamma degli utensili a catalogo. La produzione comprende una vasta gamma di utensili standard – punzoni matrici ed accessori – adatti ai vari tipi di presse piegatrici; tutti i prodotti TECNOSTAMP sono realizzati con acciai di alta qualità temprati ad induzione nelle parti usurabili per una maggiore durata e sottoposti ad un accurato controllo qualità e assistenza post vendita. Non solo prodotti standard ma soluzioni mirate per applicazioni specifiche nei vari settori della lavorazione della lamiera. La chiave del grande successo di TECNOSTAMP è proprio il servizio dedicato ai clienti: il cliente prima di tutto! L'azienda crede fortemente nella forza della sua produzione e nella competenza dei suoi collaboratori che quotidianamente mettono a disposizione le proprie capacità professionali e la propria esperienza per una continua crescita trovando soluzioni mirate e personalizzate in grado di soddisfare le esigenze dei clienti in modo veloce ed efficiente. Ricerca, innovazione, qualità e passione sono i punti forza che hanno costruito negli anni il successo del marchio TECNOSTAMP e accompagnano la sua espansione nel mercato globale.



TECNOSTAMP, founded in 1978 in Piacenza, has become over the years, one of the biggest and most important Italian companies in the production, design and sale of bending tools; It's a world-wide-expanding company with a large network of dealers across the globe. For this purpose many investments have been made: the purchase of new machines and the need to equip with advanced technologies in order to increase quality and expanding range of tools in the catalogue. The production includes a wide range of standard tools- punches, dies and accessories – suitable for all types of Press Brakes; all TECNOSTAMP products are made of high quality hardened steels for induction on wear parts for longer life and subjected to accurate quality control and after sales service. Not only standard products but targeted solutions for specific applications in the various sheet metal processing sectors. The key to great success of TECNOSTAMP is the service dedicated to customers: the customer first of all! The company strongly believes in the strength of its production and the expertise of its employees who daily make available their professional skills and experience for continuous growth by finding targeted and customized solutions that can meet customer needs quickly and efficiently. Research, innovation, quality and passion are the strengths that have built over the years the success of TECNOSTAMP brand and drive its expansion into the global market.



OUR PRODUCT LINES

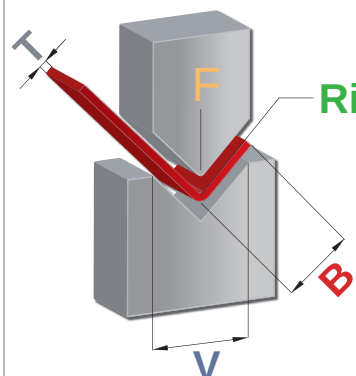


TABELLA DI PIEGATURA / BENDING CHART

FORZA NECESSARIA PER PIEGA A 90° IN ARIA DI LAMIERA CON RESISTENZA
FORCE REQUIRED FOR 90° AIR BENDING, SHEET RESISTANCE

R=45 Kg/mm²

T mm	6	8	10	12	16	20	25	32	40	50	63	80	100	125	160	200	250	V
	4	5.5	7	8.5	11	14	17.5	22	28	35	45	55	71	89	113	140	175	B
	1	1.3	1.6	2	2.6	3.3	4	5	6.5	8	10	13	16	20	26	33	41	Ri
0.5	3																	
0.6	4	4																
0.8	7	5	4															
1	11	8	7	6														
1.2	16	12	10	8	6													
1.5		17	15	13	9	8												
2			27	22	17	13	11											
2.5				35	26	21	17	13										
3					38	30	24	19	15									
4						54	42	34	27	21								
5							67	52	42	33	26							
6								75	60	48	38	30						
8									107	85	68	53	43					
10										134	105	85	67	53				
12											153	120	96	78	60			
15												188	150	120	95	75		F
20													270	215	170	135	108	t/m



SPESSORE LAMIERA IN MM
THICKNESS OF THE SHEET IN MM

FORZA IN TON / METRO
FORCE IN TON / METER

RAGGIO INTERNO
INSIDE RADIUS

BORDO MINIMO POSSIBILE
MINIMUM FLANGE LENGHT

LARGHEZZA DEL V
V-OPENING

T

F

Ri

B

V

ALLUMINIO

ALUMINIUM

R=20-25 KG/MMQ

ACCIAIO DOLCE

MILD STEEL

R=40-45 KG/MMQ

INOX

STAINLESS STEEL

R=65-70 KG/MMQ

CALCOLO DELLA FORZA PER PIEGA IN ARIA

CALCULATION OF FORCE FOR AIR BENDING

$$F = \frac{T^2 \times 2 \times R}{1.4 \times V} = \dots\dots\dots \text{Tons/mt}$$

RAPPORTO TRA SPESSORE DI LAMIERA E AMPIEZZA DEL V SHEET THICKNESS / V- WIDTH	SPESSORE LAMIERA (mm) SHEET THICKNESS (mm)	0.5 - 2.5	3 - 8	9 - 10	12 OR MORE
	AMPIEZZA DEL V (mm) V - WIDTH (mm)	6 T	8 T	10 T	12 T

LEGENDA DEI MATERIALI

MATERIAL SPECIFICATIONS

	ACCIAIO C45 (UNI EN 10083 W.1. : 1.1191). STEEL C45 (UNI EN 10083 W.1. : 1.1191).
	ACCIAIO 42CrMo4 (UNI EN 10083 W.1. : 1.7225). STEEL 42CrMo4 (UNI EN 10083 W.1. : 1.7225).
	ACCIAIO C45 (UNI EN 10083 W.1. : 1.1191) TEMPRATO AD INDUZIONE (52/55 HRC) SULLE PARTI USURABILI. STEEL C45 (UNI EN 10083 W.1. : 1.1191) INDUCTION TEMPERED (52-55 HRC) ON WEAR PARTS.
	ACCIAIO C45 (UNI EN 10083 W.1. : 1.1191) BONIFICATO R=80-85 KG/MMQ TEMPRATO AD INDUZIONE (52/55 HRC) SULLE PARTI USURABILI. STEEL C45 (UNI EN 10083 W.1. : 1.1191) HARDENED R=80-85 KG/MMQ INDUCTION TEMPERED (52-55 HRC) ON WEAR PARTS.
	ACCIAIO 42CrMo4 (UNI EN 10083 W.1. : 1.7225) BONIFICATO R=95-105 KG/MMQ TEMPRATO AD INDUZIONE (52/55 HRC) SULLE PARTI USURABILI. STEEL 42CrMo4 (UNI EN 10083 W.1. : 1.7225) HARDENED R=95-105 KG/MMQ INDUCTION TEMPERED (52-55 HRC) ON WEAR PART.

TRATTAMENTI TERMICI HARDENED TREATMENT	GLI UTENSILI STANDARD E SPECIALI SONO TEMPRATI AD INDUZIONE SULLE PARTI USURABILI A 52-55 HRC. THE STANDARD AND SPECIAL TOOLS ARE INDUCTION HARDENED TO 52-55 HRC ON WEAR PARTS.
TRATTAMENTI ANTIUSURA ANTIWEAR TREATMENT	A RICHIESTA DEL CLIENTE, SUGLI UTENSILI COSTRUITI IN 42CRM04, PUÒ ESSERE FATTO UN TRATTAMENTO ANTIUSURA DI NITRURAZIONE. ON REQUEST ON THE TOOLING IN 42CRM04 TECNOSTAMP CAN MAKE AN ANTIWEAR-NITRIDING TREATMENT.
TRATTAMENTI ANTIRUGGINE RUSTING TREATMENT	A RICHIESTA DEL CLIENTE SUGLI UTENSILI PUÒ ESSERE FATTO IL TRATTAMENTO ANTI RUGGINE DI ZINCATURA. AN ANTI RUST-GALVANIZED TREATMENT CAN BE MADE ON TOOLS ON REQUEST.

CORAL LINE

UNIBEND E ADATTATORI
UNIBEND AND ADAPTERS

SUPPORTI E MATRICI A RULLI
ADAPTERS AND ROLLER DIE

CONTENITORI E INSERTI IN POLIURETANO
POLYURETHANE INSERTS AND HOLDERS

CONTENITORI E INSERTI NYLON
NYLON INSERTS AND HOLDERS

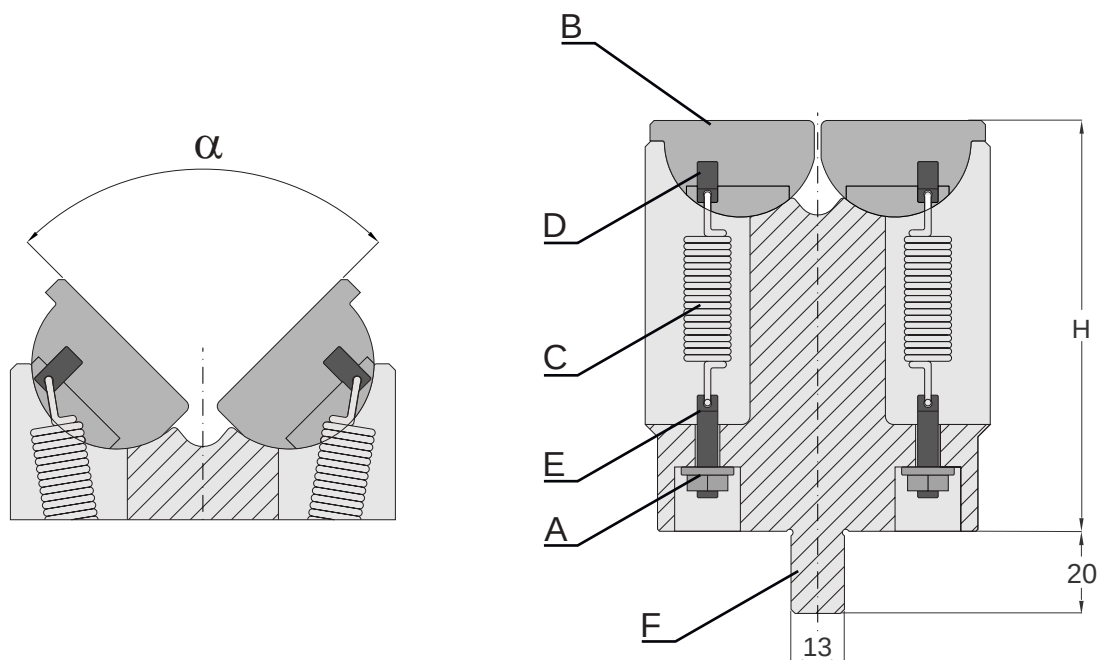
PELLICOLE ANTIGRAFFIO E TENDIPELLICOLA
PROTECTIVE FILM AND FOLDERS



CORAL LINE

UTENSILI PER NON MARCARE
NO MARKING TOOLS





50 mm | 100 mm | 200 mm | 300 mm | 500 mm

LEGENDA	α=ANGOLO	A= DADO TENSIONATORE	B= INSERTI ROTANATI	C= MOLLA A TRAZIONE	D= GANCIO CORTO	E= GANCIO LUNGO	F= CORPO MATRICE	H= ALTEZZA
LEGEND	α= ANGLE	A= TENSOR NUTS	B= ROTARY INSERTS	C= SPRING	D= SHORT HOOK	E= LONG HOOK	F= UNIBEND BODY	H= HEIGHT

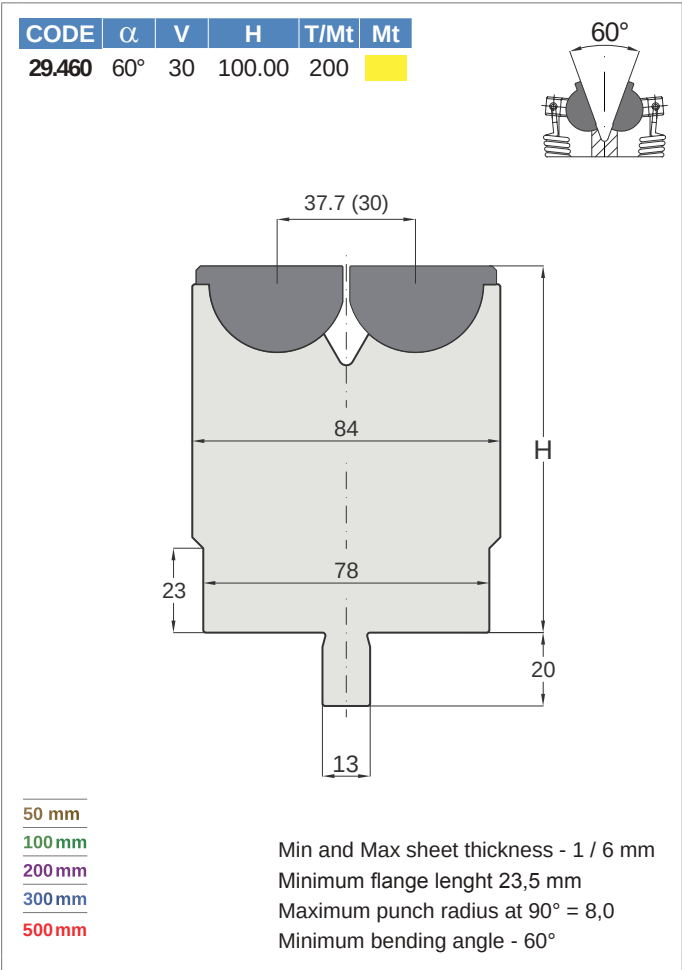
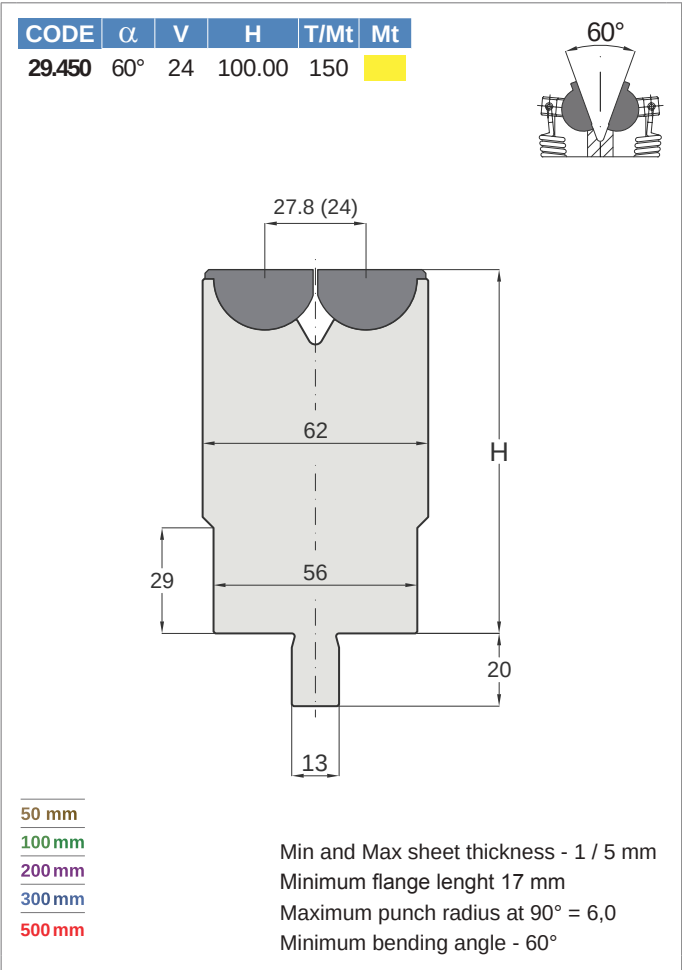
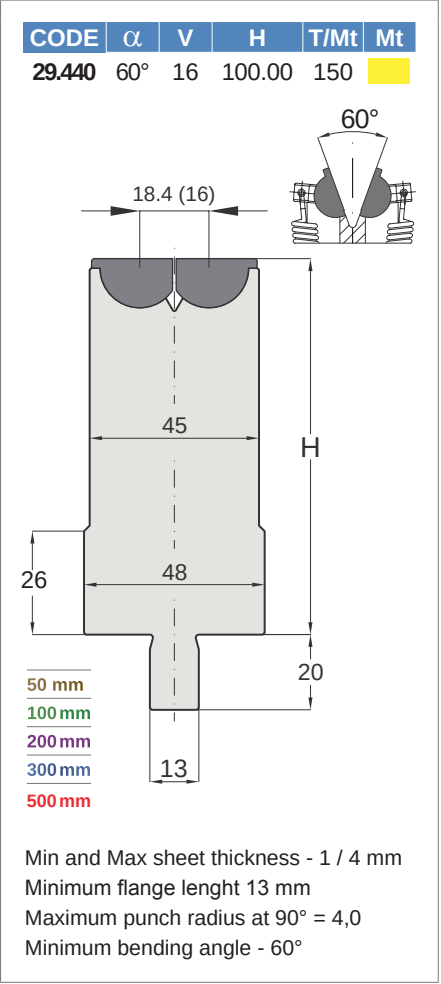
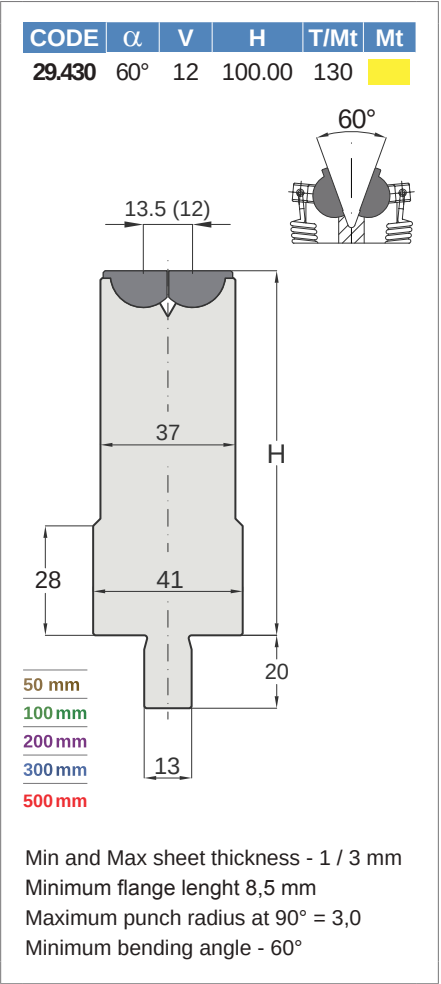
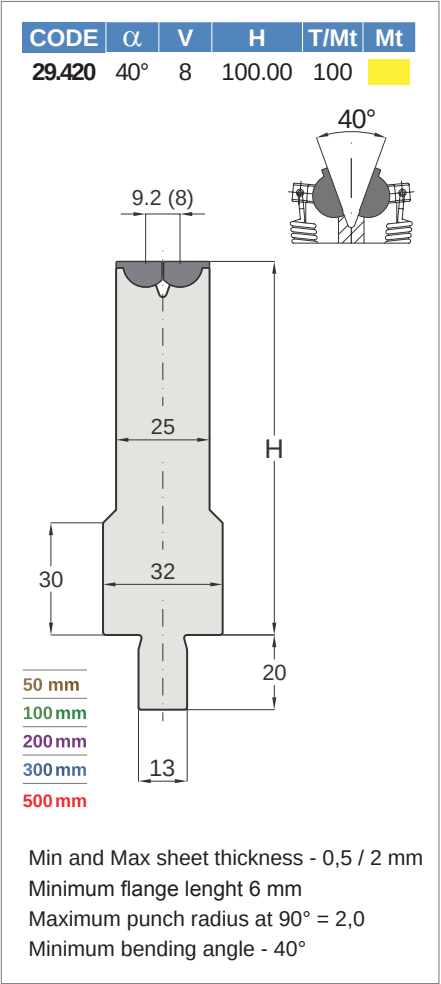
VANTAGGI DELLE MATRICI UNIBEND CON INSERTI ROTANTI:

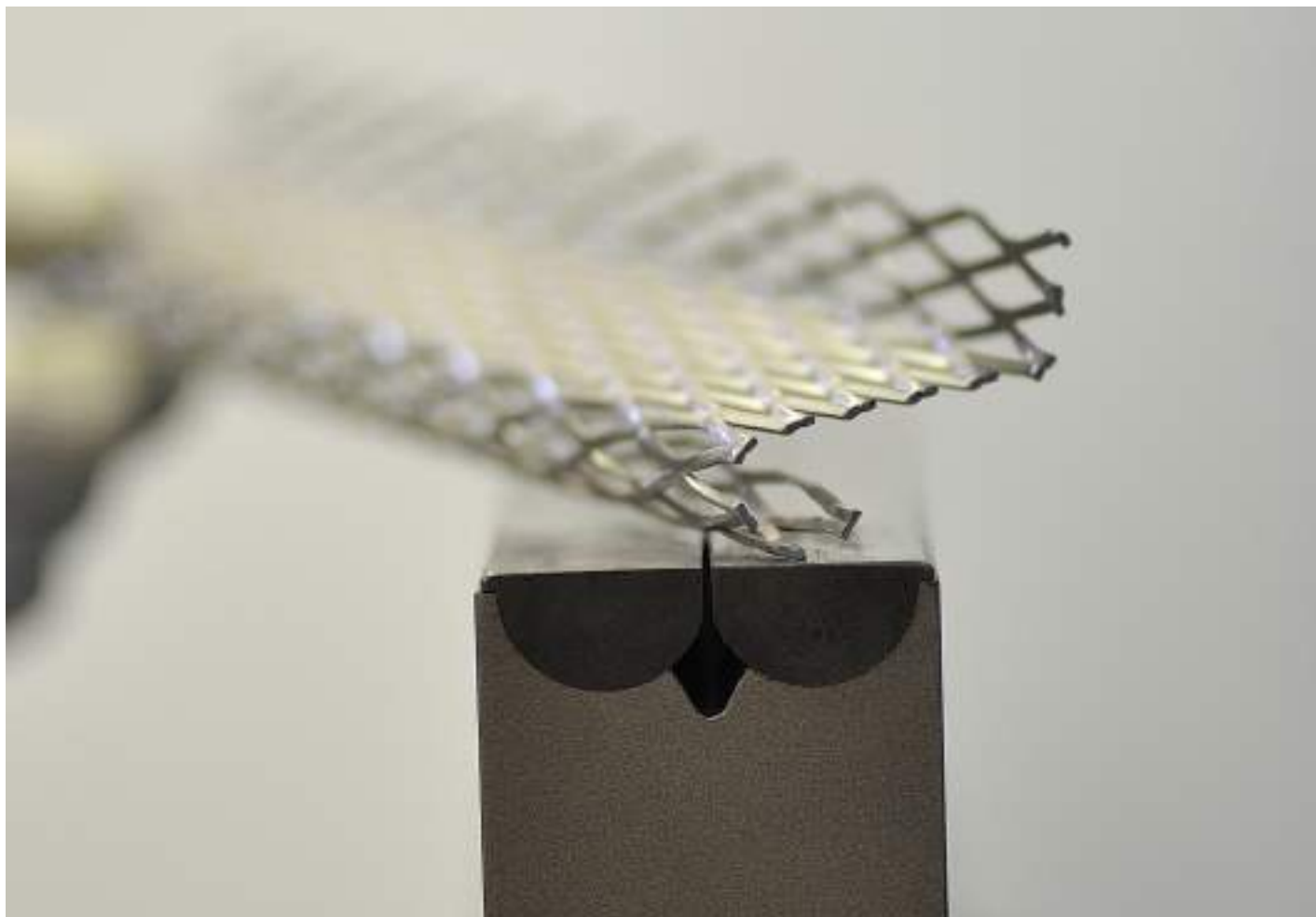
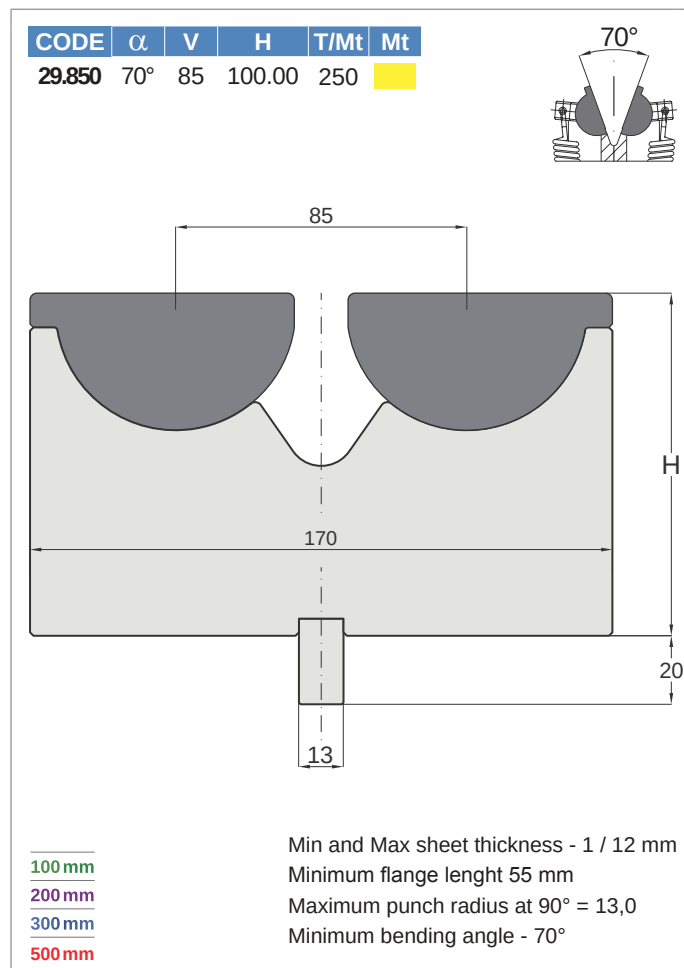
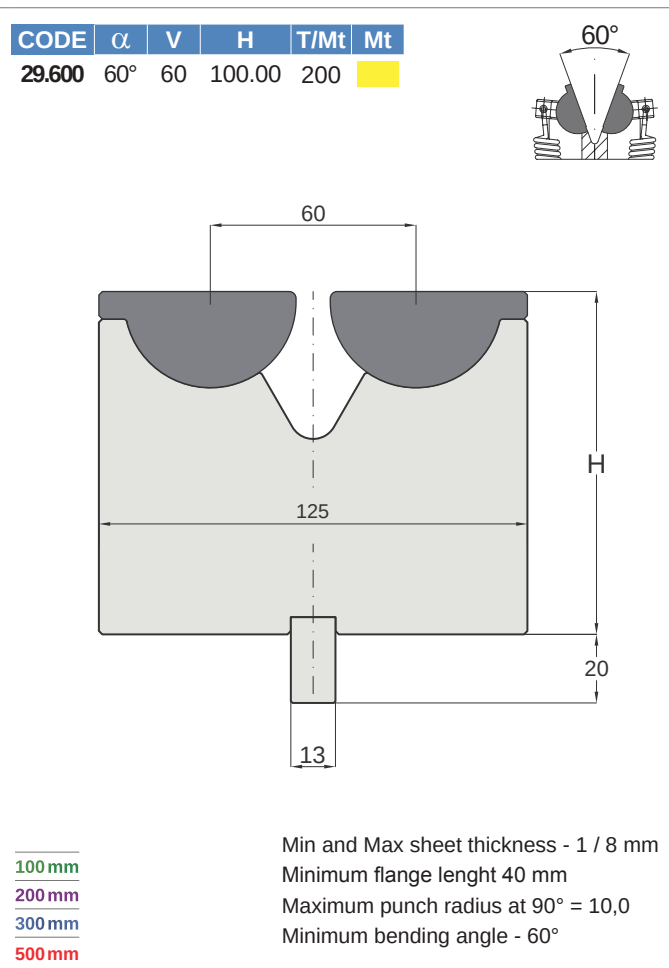
- RIDUZIONE DEI TEMPI DI CAMBIO UTENSILE POICHE' CON LA STESSA MATRICE E' POSSIBILE PIEGARE SPESSORI DIVERSI
- RIDUZIONE DEL 90% DEI SEGNI DOVUTI ALLA PIEGATURA
- POSSIBILITA' DI PIEGARE PEZZI CON BORDI STRETTI
- RIDUZIONE DELLA DEFORMAZIONE DI FORI E ASOLE VICINI ALLA LINEA DI PIEGATURA

ADVANTAGES OF THE UNIBEND DIES WITH ROTATING INSERTS :

- LESS TOOL CHANGE
- REDUCTION OF THE 90% OF THE BENDING MARKS ON SHEET
- SUITABLE FOR V, RADIUS AND U-BENDING
- REDUCTION OF DEFORMATION OF HOLES AND SLOTS CLOSE TO THE BENDING LINE

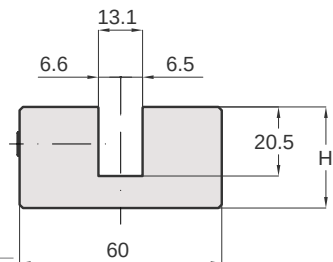
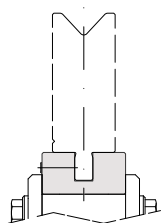






ADATTATORI INFERIORI - LOWER ADAPTERS UNIBEND

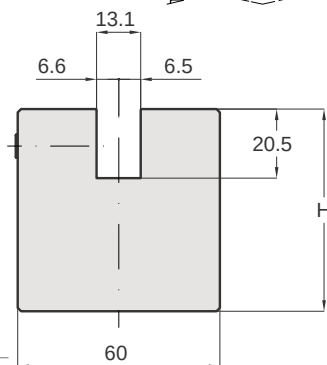
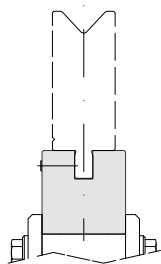
CODE	H	T/Mt	Mt
60.910	30.00	100	



50 mm
100 mm
200 mm
300 mm
500 mm
1000 mm

ADATTATORE INFERIORE - LOWER ADAPTER
AMADA / WILA - BYSTRONIC

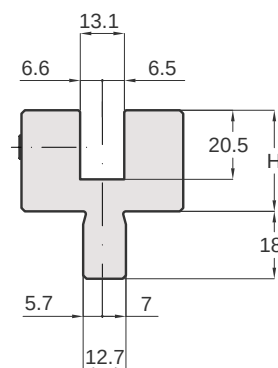
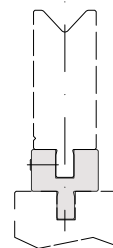
CODE	H	T/Mt	Mt
60.920	60.00	100	



50 mm
100 mm
200 mm
300 mm
500 mm
1000 mm

ADATTATORE INFERIORE - LOWER ADAPTER
AMADA / WILA - BYSTRONIC

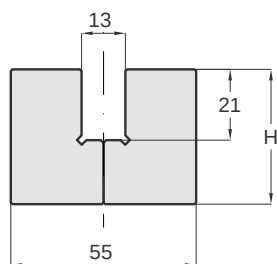
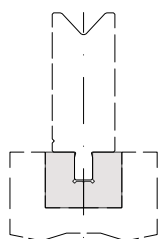
CODE	H	T/Mt	Mt
60.935	30.00	100	



50 mm
100 mm
200 mm
300 mm
500 mm
1000 mm

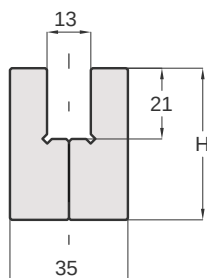
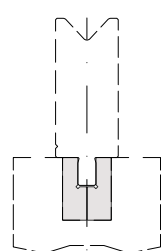
ADATTATORE INFERIORE - LOWER ADAPTER
LVD / WILA - BYSTRONIC

CODE	L	H	T/Mt	Mt
60.940	500	40.00	100	



ADATTATORE INFERIORE - LOWER ADAPTER
EHT / WILA

CODE	L	H	T/Mt	Mt
60.950	500	45.00	100	

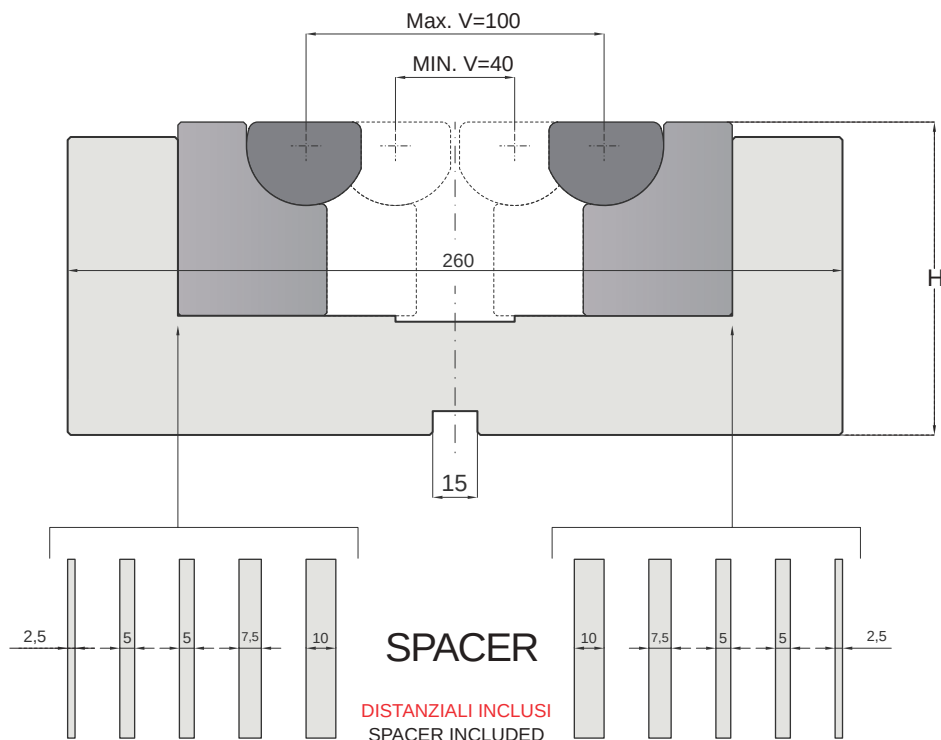


ADATTATORE INFERIORE - LOWER ADAPTER
WEINBRENNER / WILA



CODE	α	V	H	T/Mt	Mt
62.094	180°	40 - 100	105.00	150	

ROLLERS NITRIDED 60-62 HRC



Min and Max sheet thickness - 0,5 / 12 mm
 Minimum flange length 28 mm (V40) / 70 mm (V100)
 Maximum punch radius at 90° = 25
 Minimum bending angle - 180°

LEGENDA	α = ANGOLO	V = AMPIEZZA CAVA	L = LUNGHEZZA	H = ALTEZZA
LEGEND	α = ANGLE	V = DIE OPENING	L = LENGHT	H = HEIGHT

LENGTH 200

ADATTATORI ED PARTI DI RICAMBIO ADAPTERS AND SPARE PARTS

CODE	L	Mt
60.102	200	

AMADA

CODE	L	Mt
60.103	200	

WILA/TRUMPF

CODE	L	Mt
60.105	200	

LVD

CODE
40.629

100 ml
LUBRICATING GREASE

CODE	L	Mt
62.181	200	

RADIUS BENDING/OVERBENDING

CODE	L	Mt
62.182	200	

U - BENDING

CODE	L	Mt
62.183	200	

RADIUS BENDING



100 mm

LEGENDA	α = ANGOLO	B = BASE	V = AMPIEZZA CAVA	T = TEMPRA AD INDUZIONE	H = ALTEZZA
LEGEND	α = ANGLE	B = BASE	V = DIE OPENING	T = INDUCTION HARDENING	H = HEIGHT

CODE	α	H	T/Mt	Mt
20.720	80°	170.00	200	

100 mm

CODE	α	H	T/Mt	Mt
20.725	80°	200.00	200	

100 mm

CODE	α	H	T/Mt	Mt
20.732	80°	250.00	200	

100 mm

CODE	L	Mt
20.701	100	

AMADA

CODE	L	Mt
20.707	100	

EHT

CODE	L	Mt
20.709	100	

WEINBRENNER

CODE	L	Mt
20.705	100	

LVD

CODE	L	Mt
20.703	100	

WILA - BYSTRONIC



CONTENITORI E INSERTI IN POLIURETANO / HOLDERS AND POLYURETHANE INSERTS



CUSCINI IN POLIURETANO PIENI E FORATI CON RELATIVI CONTENITORI

VANTAGGI :

EVITANO I SEGNI DI PIEGATURA
IDEALE PER PIEGARE ALLUMINIO, INOX E LAMIERE PREVERNICIATE
ADATTI A PIEGHE A V , RAGGIATE E A FORMA DI U

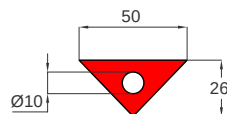
POLYURETHANE INSERTS AND HOLDERS

ADVANTAGES :

AVOIDS MARKS ON BENDED SHEETS
IDEAL FOR BENDING ALUMINIUM, STAINLESS STEEL AND PAINTED SURFACES
SUITABLE FOR V, RADIUS AND U-BENDING

LEGENDA	H = ALTEZZA	SHORE= DUREZZA
LEGEND	H = HEIGHT	SHORE= HARDNESS

CODE	H	SHORE
21.280	26.00	92



415 mm

835 mm

INSERTO IN GOMMA PER MATRICE COD. 21.207
POLYURETHANE INSERT FOR DIE COD. 21.207



CODE	H
20.271	60.00

415 mm
835 mm

CODE	H
20.272	96.00

415 mm
835 mm

CODE	H
20.273	100.00

415 mm
835 mm

CODE	H
20.274	100.00

415 mm
835 mm

CODE	H	SHORE
20.292	25.00	92

415 mm
835 mm

CODE	H	SHORE
20.291	50.00	92

415 mm
835 mm

CODE	H	SHORE
20.290	50.00	92

415 mm
835 mm

CODE	H	SHORE
20.289	50.00	92

415 mm
835 mm

CODE	H	SHORE
21.292	25.00	92

415 mm
835 mm

CODE	H	SHORE
21.291	50.00	92

415 mm
835 mm

CODE	H	SHORE
21.290	50.00	92

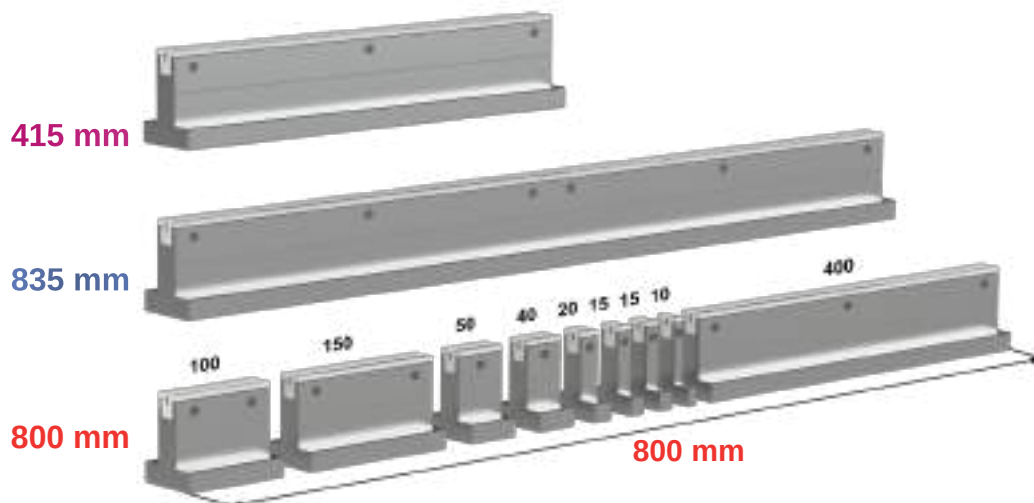
415 mm
835 mm

CODE	H	SHORE
21.289	50.00	92

415 mm
835 mm

CONTENITORI E INSERTI IN NYLON / NYLON INSERTS AND HOLDERS

CONTENITORI ED INSERTI IN NYLON STANDARD SONO DISPONIBILI A MAGAZZINO NELLE LUNGHEZZE DI: 415 / 835 E FRAZIONATI (800 mm)
 HOLDERS AND NYLON INSERTS ARE AVAILABLE IN THE FOLLOWING STANDARD LENGTHS: 415 / 835 AND SECTIONED (800 mm)



LEGENDA	α = ANGOLO	V = AMPIEZZA CAVA	H = ALTEZZA
LEGEND	α = ANGLE	V = DIE OPENING	H = HEIGHT

INSERTI IN NYLON E RELATIVI CONTENITORI

VANTAGGI:

- EVITANO I SEGNI DI PIEGATURA
- IDEALE PER PIEGARE ALLUMINIO, INOX E LAMIERE PREVERNICIATE
- CAMBIO FACILE E VELOCE

NYLON INSERTS AND HOLDERS

ADVANTAGES:

- AVOIDS MARKS ON BENDED SHEETS
- IDEAL FOR BENDING ALUMINIUM, STAINLESS STEEL AND PAINTED SURFACES
- FAST AND EASY CHANGE

CODE	H	Mt
22.001	75.00	

415 mm
835 mm
800 mm SECTIONED

AMADA - PROMECAM

CODE	H	Mt
22.002	75.00	

415 mm
835 mm
800 mm SECTIONED

AMADA - PROMECAM

CODE	H	Mt
22.003	79.00	

415 mm
835 mm
800 mm SECTIONED

AMADA - PROMECAM

CODE	H	Mt
22.004	50.00	

415 mm
835 mm
800 mm SECTIONED

WILA

CODE	H	Mt
22.005	95.00	

415 mm
835 mm
800 mm SECTIONED

WILA

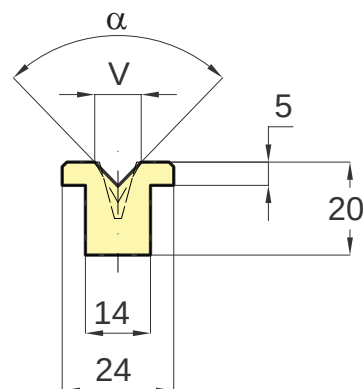
CODE	H	Mt
26.005	85.00	

415 mm
835 mm
800 mm SECTIONED

LVD

INSERTI IN NYLON / NYLON INSERTS

CODE	α	V	T/mt
31.306	30°	6	20
31.308	30°	8	20
31.406	45°	6	20
31.408	45°	8	20
31.410	45°	10	20
31.606	60°	6	20
31.608	60°	8	20
31.610	60°	10	20
31.806	88°	6	20
31.808	88°	8	20
31.810	88°	10	20



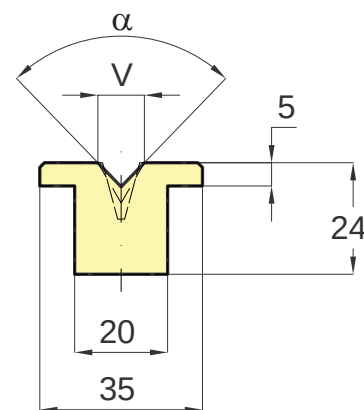
415 mm

835 mm

800 mm
SECTIONED

CODE	α	V	T/mt
32.306	30°	6	20
32.308	30°	8	20
32.310	30°	10	20
32.406	45°	6	20
32.408	45°	8	20
32.410	45°	10	20
32.412	45°	12	20
32.606	60°	6	20
32.608	60°	8	20
32.610	60°	10	20

CODE	α	V	T/mt
32.612	60°	12	20
32.616	60°	16	20
32.806	88°	6	20
32.808	88°	8	20
32.810	88°	10	20
32.812	88°	12	20
32.816	88°	16	20



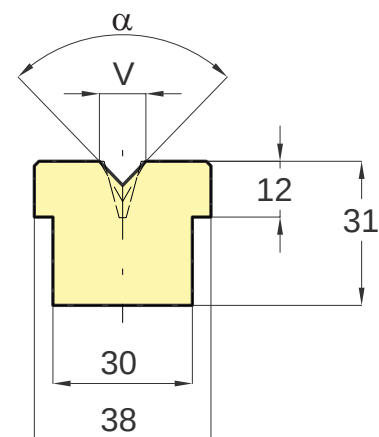
415 mm

835 mm

800 mm
SECTIONED

CODE	α	V	T/mt
33.306	30°	6	20
33.308	30°	8	20
33.310	30°	10	20
33.312	30°	12	20
33.316	30°	16	20
33.406	45°	6	20
33.408	45°	8	20
33.410	45°	10	20
33.412	45°	12	20
33.416	45°	16	20
33.420	45°	20	20
33.606	60°	6	20

CODE	α	V	T/mt
33.608	60°	8	20
33.610	60°	10	20
33.612	60°	12	20
33.616	60°	16	20
33.620	60°	20	20
33.806	88°	6	20
33.808	88°	8	20
33.810	88°	10	20
33.812	88°	12	20
33.816	88°	16	20
33.820	88°	20	20
33.825	88°	25	20



415 mm

835 mm

800 mm
SECTIONED



CODE	S	L
40.810	0.8	95



THICKNESS

95

LENGHT | 33 mt

LEGENDA	S= SPESSORE PELLICOLA	L= LARGHEZZA PELLICOLA	T= SPESSORE LAMIERA (mm)
LEGEND	S= FILM THICKNESS	L= FILM WIDTH	T= SHEET METAL THICKNESS (mm)

CODE	S	L
40.815	0.3	95



THICKNESS

S=0.3

95

LENGHT | 33 mt

CODE	S	L
40.820	0.5	95



THICKNESS

S=0.5

95

LENGHT | 33 mt

CODE	S	L
40.830	0.5	35



THICKNESS

S=0.5

35

LENGHT | 33 mt

CODE	S	L
40.835	1,5	200



THICKNESS

S=1.5

200

LENGHT | 15 mt

CODE	S	L
40.840	0,5	150



THICKNESS

S=0.5

150

LENGHT | 33 mt

CODE	S	L
40.845	2	250



THICKNESS

S=2

250

LENGHT | 10 mt

CODE

40.800



STANDARD SYSTEM

Max = 100mm

CODE

40.850

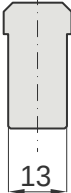


MAGNETIC SYSTEM

Max = 150mm

CODE

60.110



ADATTATORE INFERIORE
LOWER ADAPTER

40.800 - 40.860
MODELLI COMPATIBILI
COMPATIBLE MODELS

WILA/TRUMPF-BYSTRONIC

TABELLA DI PIEGATURA
BENDING CHART

CODE	S	T
40.810	0.8	1 mm to 3 mm
40.815	0.3	0.2 mm to 1 mm
40.820	0.5	0.5 mm to 1.5 mm
40.830	0.5	0.5 mm to 1.5 mm
40.835	1.5	2 mm to 4 mm
40.840	0.5	0.5 mm to 1.5 mm
40.845	2	3 mm to 6 mm

CODE

40.860



STANDARD SYSTEM

Max = 250mm

